

Work Order ID 64627

Page 1

Thursday, December 09, 2010 12:52:59 PM

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 12/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-12-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| D3929 | A | | | | | | | | |

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

8/12/14

(x6)

140



Large Fab

Large Fab

Memo

0.00

8/10/12/20 (ex)

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 4119649

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

CPL 10.12.20

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 64627

Thursday, December 09, 2010 12:52:59 PM



Page 3

Item ID: D3929-042

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Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 12/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/20

(X6)

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Basket cell

Memo

0.00

10/10/20

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/20

10/12/20

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NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 12:53:03 PM

Page 1

Work Order ID: 64627



Parent Item: D3929-042



Parent Item Name: Gusset Assembly

Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-------------------|
| M304S11GA | | Purchased | No | | | 100 | sf | 16.7003 | 0.45 | 2.842105 | | | <i>12/0-12-13</i> |

304/316 0.125 Sheet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT | 16.7003 | |
| | 16.7003 | |

D3907-1



Bushing

| | | | | | | | |
|--------------|----|--------|-----|------|---------|---|------------------------|
| Manufactured | No | 114799 | 130 | Each | 21.0000 | 2 | 12 |
| | | | | | | | <i>12/10/10/12/116</i> |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| WA | 21 | |
| | 21 | |

12x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|-----------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 646027 |
| Description: Support Gusset | Part Number: | D3929-1 |
| Inspection Dwg: D3929 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

| | | |
|------------------------|-----------------------|-------------------------|
| Measured by: <u>IB</u> | Audited by: <u>8</u> | Prototype Approval: N/A |
| Date: <u>10-12-13</u> | Date: <u>10/12/14</u> | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 09.05.27 | New Issue P/O D3929-041/-042 | KJ | DS |

8

7

6

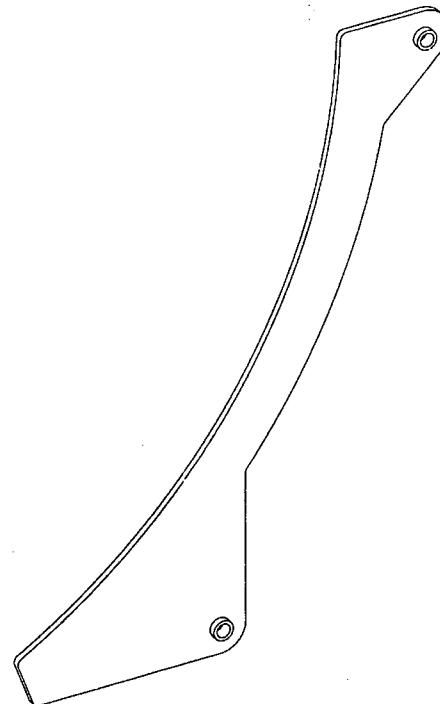
5

4

3

2

1



| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|-----------------|
| 1 | X | | D3929-041 | GUSSET ASSEMBLY |
| 2 | | X | D3929-042 | GUSSET ASSEMBLY |
| 11 | 2 | 2 | D3907-1 | BUSHING |
| 12 | 1 | 1 | D3929-1 | SUPPORT GUSSET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. U46627

28/10/12-9

RELEASED
07/09/12 MHD

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

| A | NEW ISSUE | MB | 09.04.03 |
|------------|-------------|-----------------------------|--------------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>5</i> | DART AEROSPACE LTD | |
| DRAWN | <i>5</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>PA</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>MA</i> | D3929 | SHEET 1 OF 3 |
| APPROVED | <i>MP</i> | TITLE | SCALE |
| DE APPR. | <i>MP</i> | GUSSET ASSEMBLY | |
| DATE | 09.04.03 | NTS | |

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8

7

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1

A

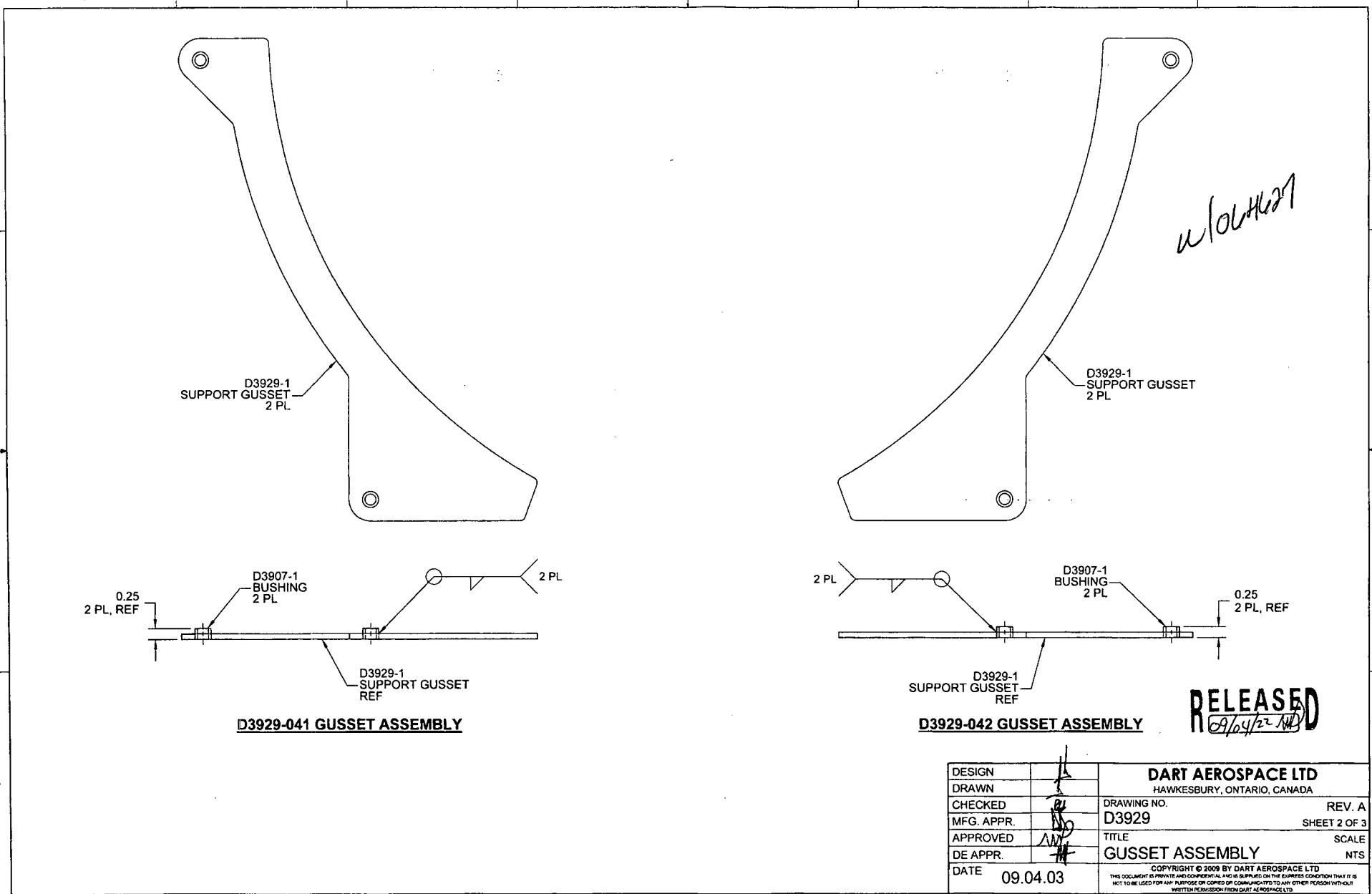
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NOTE: Date & initial all entries



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| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | REV. A |
| MFG. APPR. | | D3929 |
| APPROVED | | SHEET 2 OF 3 |
| DE APPR. | | |
| DATE | 09.04.03 | SCALE |
| | | NTS |
| | | GUSSET ASSEMBLY |
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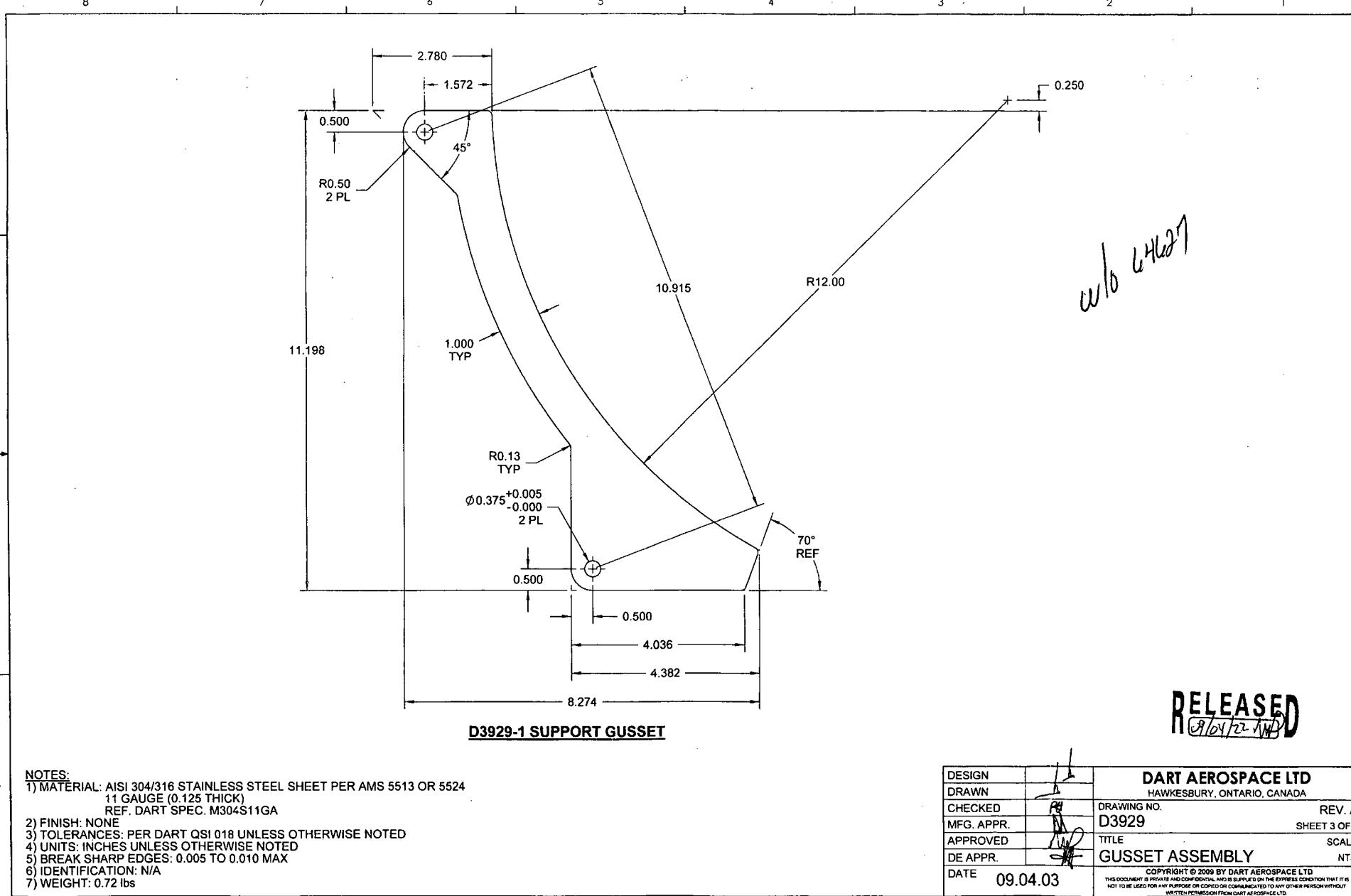
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| MFG. APPR. | | D3929 | SHEET 3 OF 3 |
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GUSSET ASSEMBLY

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